

Date: Monday, 07/07/2008 8:36:17 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CLEVIS
Job Number :	40311		
Estimate Number :	13301		
P.O. Number :		Part Number :	D37651
This Issue :	07/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3765 REVA
First Issue :	1/1	Project Number :	N/A
Previous Run :	39030	Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	30/07/2008
Written By :		Qty:	12
Checked & Approved By :	JLM 08.7.07	Um:	Each
Comment :	Est Rev:A New Issue 08-05-05 JLM Verified By:EC		
	Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1000	ROUND BAR 1.00"
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Comment: Qty.: 0.1969 f(s)/Unit Total : 2.3625 f(s)

ROUND BAR 1.00"

Batch: M6147

RQ 08/07/08

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: Doosan Lathe

1- Turn as per Folio FA744 Rev: A & Dwg D3765 Rev: A

2-Deburr per dwg D3765

RQ 08/07/08

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RQ 08/07/08

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1-SLIT PART USING 4" -7/32" WITH .063" RAD SLITTING SAW

2-DEBURR

RQ 08/07/08 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 8:36:17 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 40311

Part Number: D37651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RP 08/07/08

(12)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/07/09

(12)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AS

08-07-09

(X12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 08/07/09

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 119*

AS

08/07/10

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/10

Job Completion



MF 08-07-10

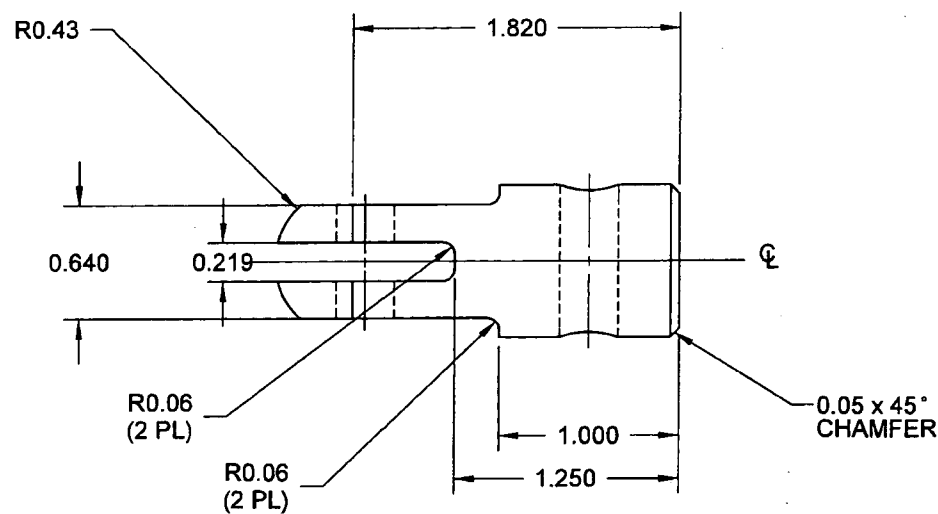
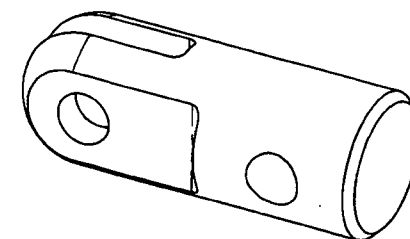
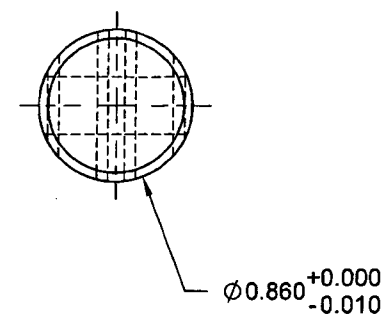
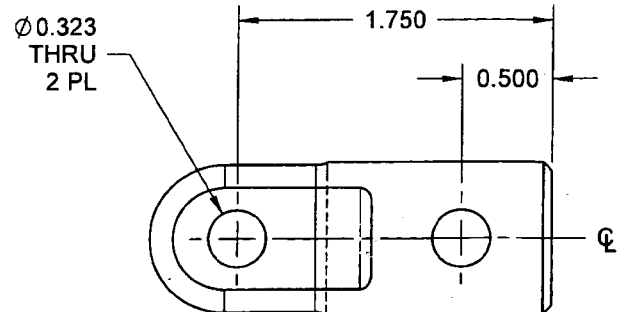
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



2.247
over

D3765-1 CLEVIS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40311

RELEASED
08-06-16

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	HS	D3765	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	CLEVIS	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:	40311
Description: Crosstube Assembly <i>Clevis</i>		Part Number:	D3765-1
Inspection Dwg: <i>2</i>	Rev: <i>A</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	1.750	$\pm .010$	1.747				
	.323	$\pm .006 - .001$.325				
	.500	$\pm .010$.497				
	1.820	$\pm .010$	1.825				
	R.43	$\pm .03$.43				
	.640	$\pm .010$.643				
	.219	$\pm .010$.218				
	R.06	$\pm .030$	R.06				
	R.00	$\pm .030$	R.06				
	1.250	$\pm .010$	1.247				
	1.000	$\pm .010$	1.001				
	.05 x 45°	$\pm .030$.05 x 45°				
	.850	$\pm .010$.855				
SIDE B							

Measured by: <i>RJ</i>	Audited by: <i>J.F.</i>	Prototype Approval:	N/A
Date: <i>05/07/08</i>	Date: <i>08/07/09</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	